

Date: Wednesday, 6/6/2007 1:59:36 PM
 User: Kim Johnston

Process Sheet

Split 07.06.13

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 32808 -1	
Estimate Number : 12403	
P.O. Number : N/A	Part Number : D3511041
This Issue : 6/6/2007 S.O. No. : N/A	Drawing Number : D3511 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 27679	Material : N/A
Written By : <u>JA 07.06.07</u>	Due Date : 6/28/2007
Checked & Approved By : <u>JA 07.06.07</u>	Qty: 10 Um: 8 Each
Comment : Est Rev:A New Issue 06-05-04 JLM	
Est Rev:B New process 06-05-05 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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Comment: Qty.: 1.5572 sf(s)/Unit Total : 12.4572 sf(s)
 304 SHEET .188" THICK
 (M304S0188)
 Batch: M104699

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3511
 Dwg Rev: A
 Prog Rev: A

2-Debur if necessary

Identify as D3511-1

SAD

07/06/12

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/06/12

11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/06/12

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-13	2-0	Split w/o for qty 11 of 12. 11 on this w/o, and 1 part on split (see NCR on split).	<i>[Signature]</i>	07-06-13	11	<i>[Signature]</i> QS1012	<i>[Signature]</i> 07-06-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:37 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32808

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

CUP

Batch:

B27220-7

B2827
B2827-81

AD 07-06-14

10

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 07/06/13

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2-06-13 (11)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch:

H102756

AD

07-06-14

(11)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 07/06/14

(11)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

A 07/06/14 (11)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2-06-14 (11)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

H 102 316

BR/M 07-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:37 PM
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Drawing Name: WEARPLATE

Job Number: 32808

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/6/15 SP



W

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-19

W

7/6/15

SP

15.0

QC21

FINAL INSPECTION/W/O RELEASE



11

Comment: FINAL INSPECTION/W/O RELEASE

5/19/10/15

Job Completion



W 8/10/15

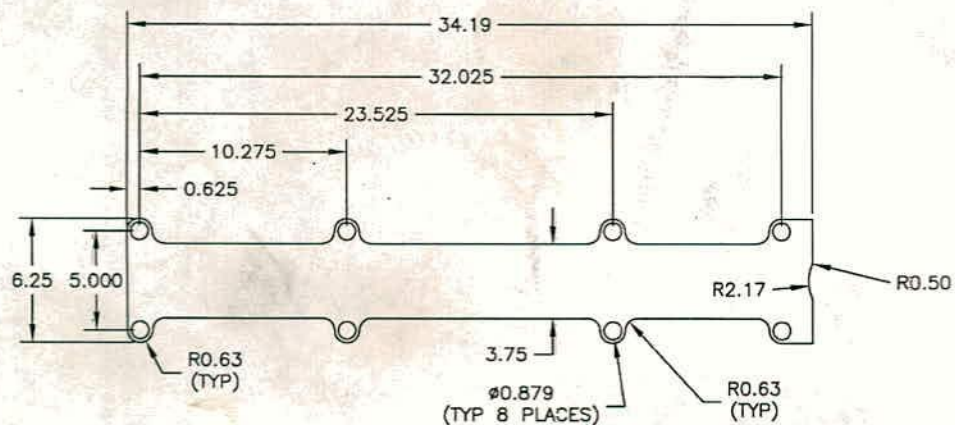
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

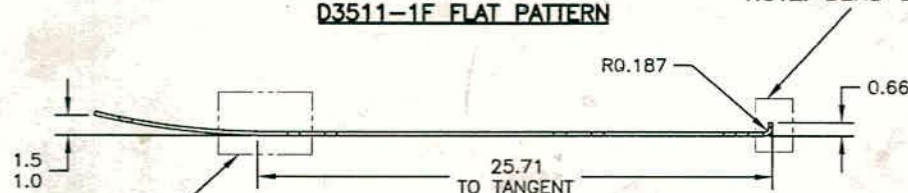
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



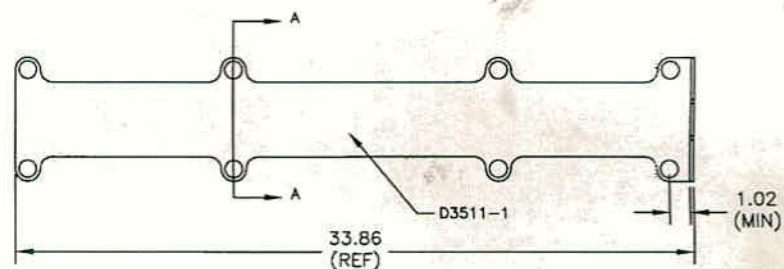
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



NOTE: BEND AFTER WELDING

D3511-1 BEND DETAIL



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AN ENDORSEMENT
 WITHOUT NOTICE
 WORK ORDER
 32808

RELEASED

06 04 25

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A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.04.04	
		DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3511
		TITLE WEARPLATE
		REV. A SHEET 1 OF 1 SCALE NTS

